

**Work Order ID 63570**

Thursday, November 04, 2010 1:13:31 PM



Page 1

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 11/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date: 10-11-04 Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop


**Sequence ID/  
Work Center ID**
**Operation  
Description**
Set Up/  
Run Hours

Tool ID

Tool #  
CodePlan  
QtyAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr	Revision Nbr
D3536	Rev A

100



FLOW WATER JET

Waterjet

## Memo

0.00

B10-11-16

FLOW CNC Waterjet

1-Cut as per Dwg D3536  Dwg Rev: A  Prog Rev: A  2-  
Deburr if necessary

110



QC2- Inspect parts off machine FAI/FAIB

QC

0.00

B10-11-16

Quality Control

## Memo

0.00

120



QC8- Inspect parts - second check

QC

0.00

Quality Control

## Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 63570**

Thursday, November 04, 2010 1:13:31 PM



Page 2

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 11/4/2010 Start Qty: 12.00



Cust Item ID:

Required Date: 11/12/2010 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center ID

130



Packaging

Packaging

Operation  
DescriptionIdentify as per dwg & Stock Location: FR11Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

*10/11/11* *12x*



QC

Quality Control

Memo

0.00

*10/11/11* *12*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Thursday, November 04, 2010 1:13:35 PM

Page 1

Work Order ID: 63570



Parent Item: D3536-23



Parent Item Name: Gasket

Start Date: 11/4/2010

Required Date: 11/12/2010

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	495.6220	1.3365	17.82		 18 10-11-16	

NEOPRENE SHEET 0.063

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT	495.622	
115500	95.622	
115916	400	115916

(12)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	63576
Description: Gasket	Part Number:	D3536-23
Inspection Dwg: D3536	Rev: A	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

First Article     Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
52.85	+/-0.030	52.85	✓		T 1B01	
48.20	+/-0.030	48.20	✗		T	
44.70	+/-0.030	44.70	✗		T	
39.31	+/-0.030	39.31	✗		T	
33.92	+/-0.030	33.92	✗		T	
28.53	+/-0.030	28.53	✗		T	
23.14	+/-0.030	23.14	✗		T	
17.75	+/-0.030	17.75	✗		T	
14.25	+/-0.030	14.25	✗		T	
9.50	+/-0.030	9.50	✗		T	
4.75	+/-0.030	4.75	✗		T	
8.00	+/-0.030	8.00	✓		T	
16.00	+/-0.030	16.00	✗		T	
24.00	+/-0.030	24.00	✗		T	
32.00	+/-0.030	32.00	✗		T	
39.00	+/-0.030	39.00	✗		T	
48.00	+/-0.030	48.00	✗		T	
0.30	+/-0.030	0.30	✗		U 1B02	
0.30	+/-0.030	0.298	✗		U	
1.89	+/-0.030	1.895	✗		U	
Ø0.19	+0.005/-0.001	190	✗		✗	

Measured by:	BR	Audited by:	8	Prototype Approval:	N/A
Date:	10-11-16	Date:	10/11/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	SP

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

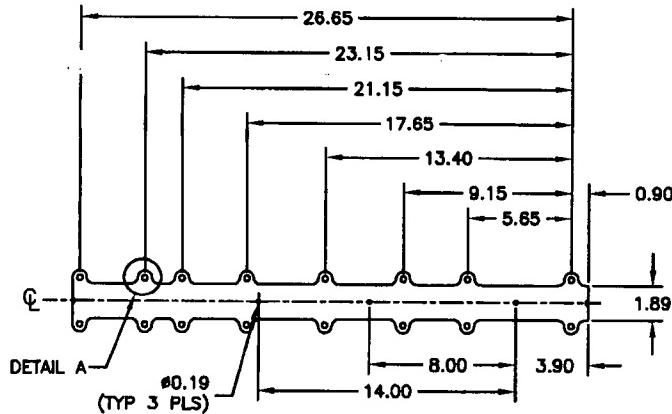
NOTE: Date & initial all entries

**DART**

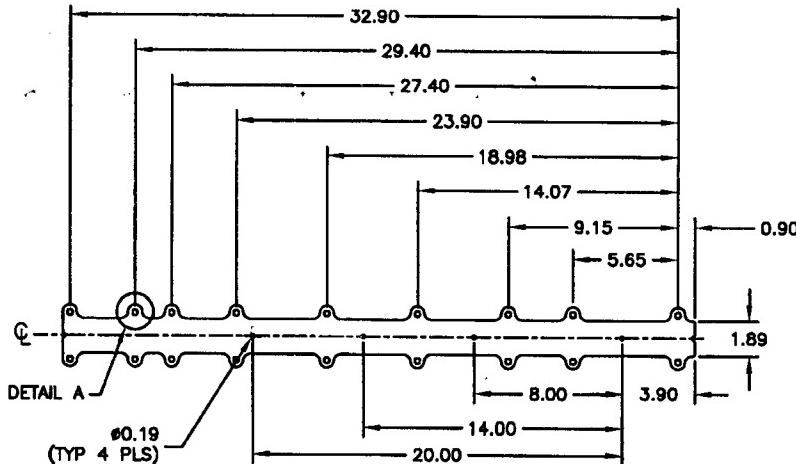
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C B	C B	P.O. HADLOCK, WA
CHECKED	APPROVED	REV. A
Pf	H	
DATE		SHEET 1 OF 6
06.10.25		1:10
A	06.10.25	SCALE
	NEW ISSUE	

RELEASED  
09-02-12

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 13536  
*B8011-04*



**D3536-11 GASKET**



**D3536-13 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

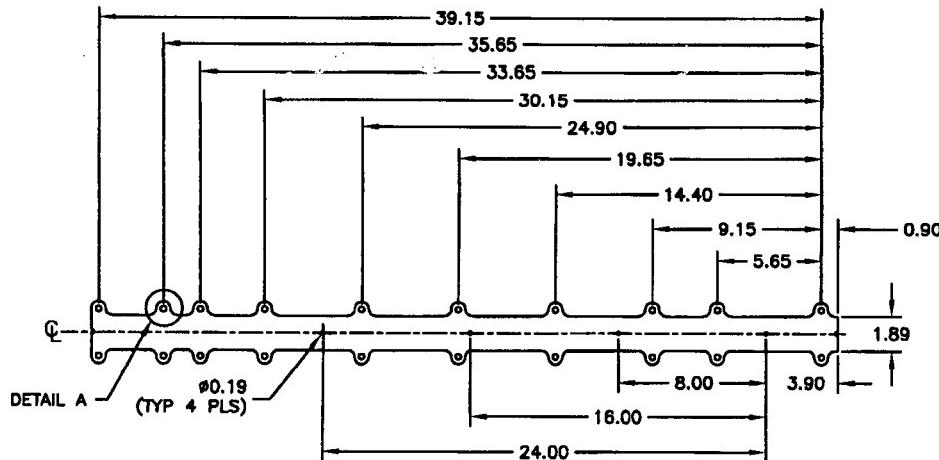
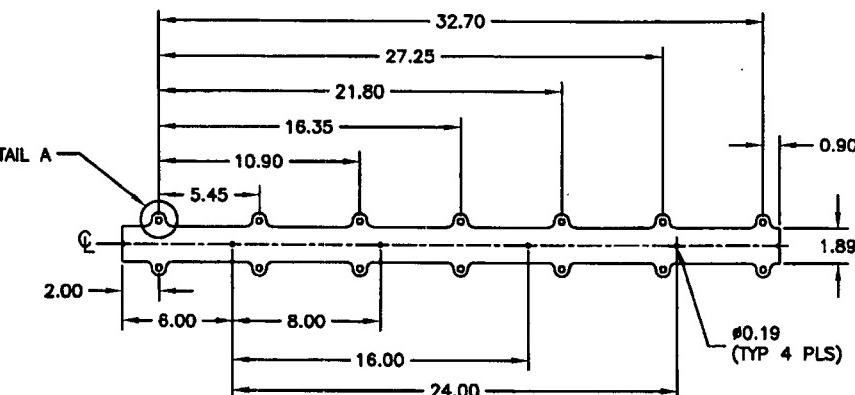
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN CB	DRAWN BY CB	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <i>M</i>	APPROVED <i>M</i>	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 2 OF 6 SCALE 1:10

07.02.12 *H*

**D3536-15 GASKET***w/v 43570***D3536-21 GASKET**

- NOTES**
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
  - 2) FINISH: NONE
  - 3) PART IS SYMMETRICAL ABOUT  $\frac{C}{2}$
  - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 5) ALL DIMENSIONS ARE IN INCHES
  - 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
  - 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

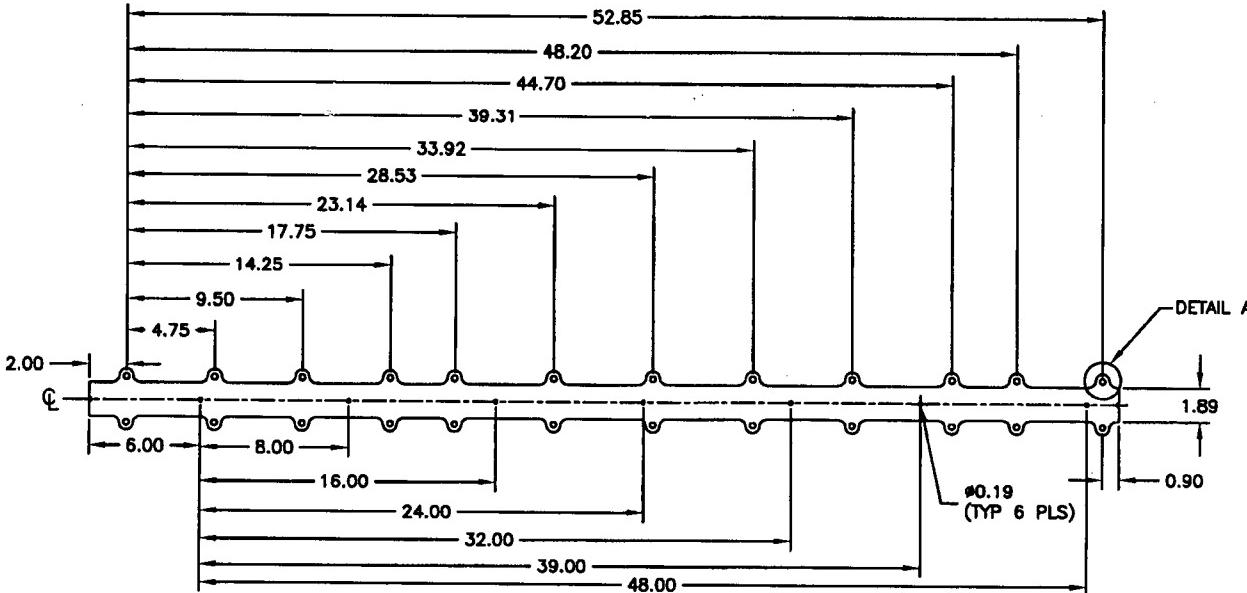
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

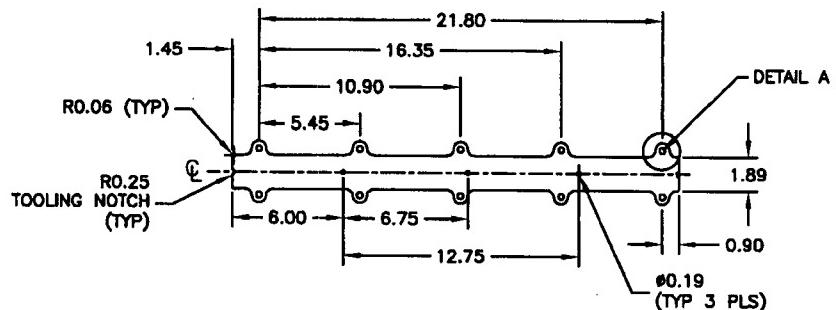
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DESIGN <b>C B</b>	DRAWN BY <b>C B</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED <b>Pf</b>	APPROVED <b>H</b>	DRAWING NO. <b>D3536</b>
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	REV. A SHEET 3 OF 6 SCALE <b>1:10</b>

07-02-12  
H

**D3536-23 GASKET**

w/043570

**D3536-25 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

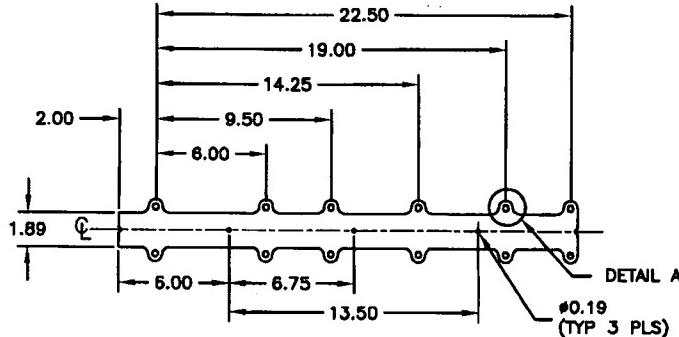
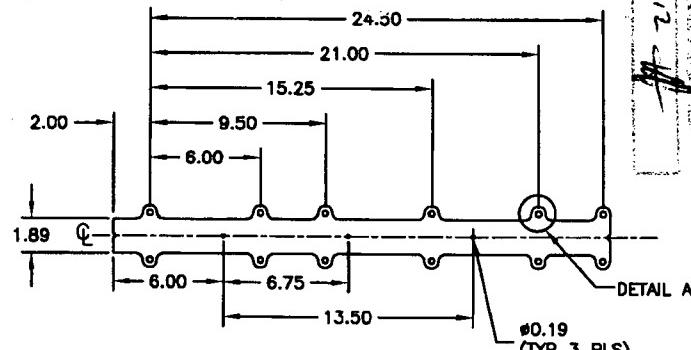
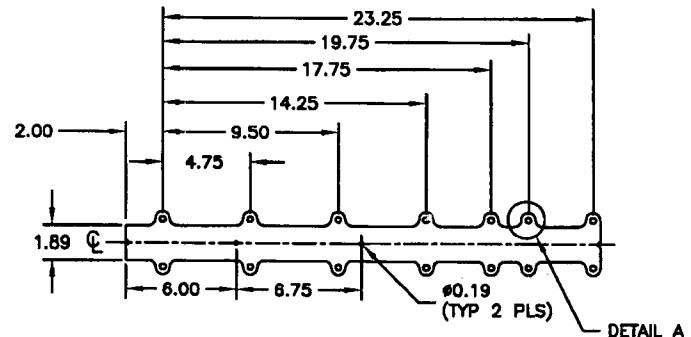
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <b>CB</b>	DRAWN BY <b>CB</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED <b>M</b>	APPROVED <b>H</b>	DRAWING NO. D3536
DATE 06.10.25		TITLE GASKET
		REV. A SHEET 4 OF 6 SCALE 1:10

07.02.12

**D3536-31 GASKET****D3536-33 GASKET****D3536-35 GASKET****NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

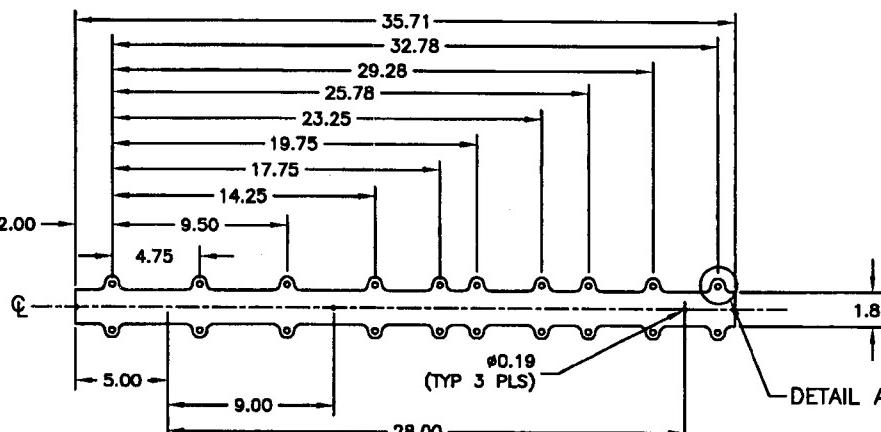
NOTE: Date & initial all entries

**DART**

DESIGN <b>C8</b>	DRAWN BY <b>CB</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA.	
CHECKED <b>P4</b>	APPROVED <b>H</b>	DRAWING NO. <b>D3536</b>	REV. A SHEET 5 OF 6 SCALE <b>1:10</b>

0702.12 *[Signature]*

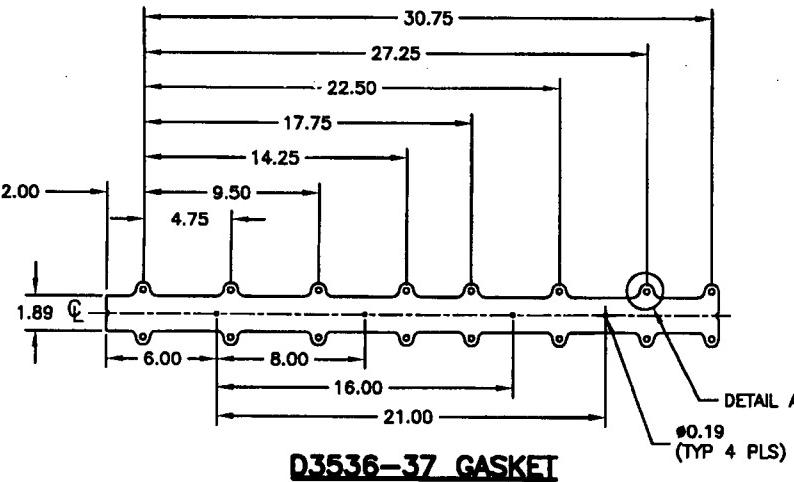
u/o 43570



**D3536-39 GASKET**

**NOTE:**

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE080-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



**D3536-37 GASKET**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

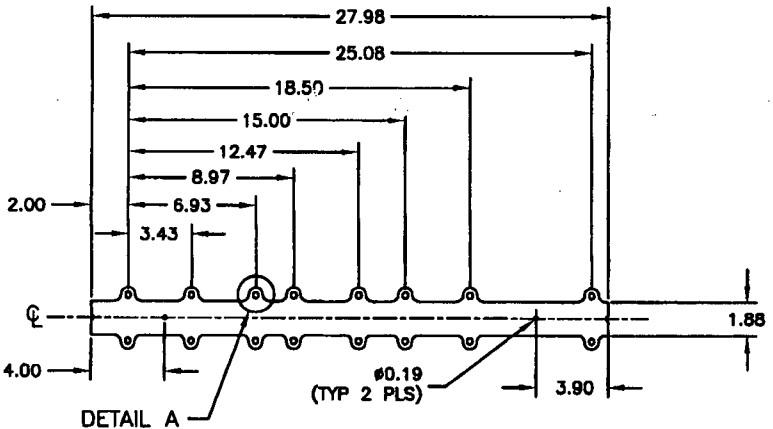
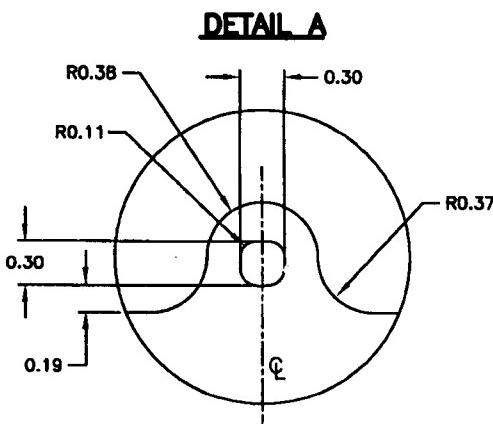
NOTE: Date & initial all entries

**DART**

DESIGN <b>C.B</b>	DRAWN BY <b>C.B</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA
CHECKED <b>H</b>	APPROVED <b>H</b>	DRAWING NO. <b>D3536</b>
DATE <b>06.10.25</b>	TITLE <b>GASKET</b>	SHEET 6 OF 6
		SCALE <b>1:10</b>

07.02.12 *H*

W063570



**D3536-41 GASKET**

**NOTES**

- 1) MATERIAL: BLACK NEOPRENE SHEET. 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT  $\text{\textcircumflex}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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